



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW1205G00231-3G
Job Sheet 178058



001515

Part No: RBW1205G00231-3G

Job Qty: 1 ea

Part Name: Main Rotor Damper Oil Filling Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/25/18

Job Tracking No:

Due Date: 6/18/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBW1205G00231-3G Rev 2B IPP Rev A 18.02.14m New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/18/18	6/18/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	1 pcs	6/18/18	6/18/18	0.25	0.25	Small Fab-9		MLL
110	QC	1 pcs	6/18/18	6/18/18	0.00	0.00	QC5		SB
130	Packaging	1 pcs	6/18/18	6/18/18	0.00	0.00	Packaging3-2		MLL
140	QC21-FG	1 Ea	6/18/18	6/18/18	0.00	0.00	QC21		DAS

Part Op 100 - Assemble as per DWG.
Descriptions: 130 - Identify and Stock

JUL 19 2018

53
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91611A108	Spring Pin 2mmRND x 18mm	2 Ea (2 ea)	90-Start up Operation	5004183
AN815-6D	Union M Flare	1 Ea (1 ea)	90-Start up Operation	5023002
RBW1205G00231-3G-1	Body	1 Ea (1 ea)	90-Start up Operation	5091802
RBW1205G00231-3G-3	Tube	1 Ea (1 ea)	90-Start up Operation	5063289
RBW1205G00231-3G-5	Pressure Relief Plug (Modified B/O)	1 Ea (1 ea)	90-Start up Operation	5089892
RBW1205G00231-3G-7	Washer	1 Ea (1 ea)	90-Start up Operation	5092496
V75-010	Oring	2 Ea (2 ea)	90-Start up Operation	5038451
V75-011	Viton 75D Brown Oring	1 Ea (1 ea)	90-Start up Operation	5038453
V75-013	Viton 75D Oring	1 Ea (1 ea)	90-Start up Operation	5038452

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91611A108	2	192	0
	AN815-6D	1	28	0
	RBW1205G00231-3G-1	1	0	0
	RBW1205G00231-3G-3	1	17	0
	RBW1205G00231-3G-5	1	0	0
	RBW1205G00231-3G-7	1	3	0
	V75-010	2	36	0
	V75-011	1	43	0
	V75-013	1	43	0

Part Specifications

Specifications could not be found.



Container No: S093719



Part: RBW1205G00231-3G

Job No: 178058

Serial No/Batch: S093719

Revision: 28

Inspector:

Exp Date:

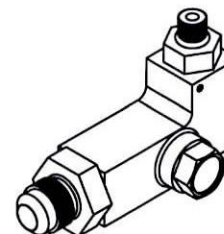
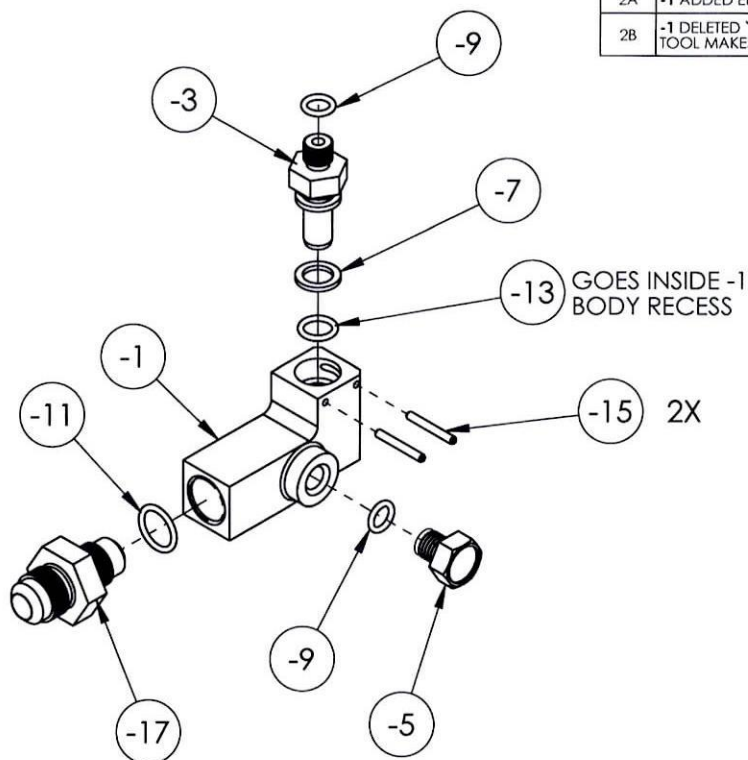
Instructions:

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Email: sales@dartaero.com
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Date: 07/19/18

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED PART -17, -1 REMOVED 7/16-20 THREADED NIPPLE, MOVED RELIEF VALVE .100.	2/24/2011	JAG	
2	-1 CH'D TO USE PORTING TOOL 2 PLACES.	12/20/2011	JAG	
2A	-1 ADDED ENGRAVE NOTE PER S.E.	3/28/2012	RJC	SE
2B	-1 DELETED $\nabla \phi .37 \times 90^\circ$, NEAR SIDE CALLOUT FROM 5/16-24 $\nabla .50$ BECAUSE 5/16-24 PORTING TOOL MAKES THIS FEATURE	1/21/2014	DPD	GE



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178058
20180622

FUNCTION: PART OF HELICOPTER SERVICING KIT T/N 3G1205G00131.
USED IN CONJUNCTION WITH A MANUAL HYDRAULIC OIL PUMP TO
RESTORE THE HYDRAULIC OIL LEVEL INTO THE M/R DAMPER

ORIGINAL No. REF
RBW1205G00231-3G = 3G1205G00231
RBW1205G00213-3G-1 = 3G1205G00651
RBW1205G00231-3G-3 = 3G1205G00551
DO NOT USE, FOR REGERENCE ONLY

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061	1-1/8 X 1-3/8 X 2-3/16	2
			-3	1	TUBE	6061	Ø3/4 X 1-1/2	3
			-5	1	AN PRESSURE RELIEF PLUG	ALUMINUM	AIRCRAFT SPRUCE #AN814-2D (MODIFIED)	4
			-7	1	WASHER	NYLON	Ø1/2 X 3/16	5
		B/O	-9	2	O-RING	VITON	ID 1/4 X 1/16 WIDTH #V75-010	1
		B/O	-11	1	O-RING	VITON	ID 7/16 X 1/16 WIDTH #V75-013	1
		B/O	-13	1	O-RING	VITON	ID 5/16 X 1/16 WIDTH #V75-011	1
		B/O	-15	2	ROLL PIN	STEEL	Ø2mm X 18mm MCMaster-CARR #91611A108	1
		B/O	-17	1	FITTING	ALUMINUM	MS24392D6	1

RED BARN MACHINE	
TITLE MAIN ROTOR DAMPER OIL ADAPTER	
DWG NO. RBW1205G00231-3G	REV 2B
MATL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: PERRITT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA
SCALE 1:2	DATE 2/23/2011 SHEET 1 OF 5

178048

Page 1 of 1

Measured by:		Checked by:		QC Inspector:	
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge
☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier
				☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing
				☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due
				☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks
				☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat
				☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up
				☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination
				☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes
				☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld
				☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Misabeled
				☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions
				☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved
				☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
OTHER : _____							